

Work Order ID 146864

Tuesday, May 24, 2016 9:58:04 AM

146864

Page 1

Item ID: D4271-027

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: End Fitting Assembly Aft Beam

Start Date: 6/8/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/10/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4271

D

0.00

Pick Kit

DAS
6
9-89

SEP 11 7 2016

100

100

Small Fab

Small Fab

Memo

0.60

Assemble as per dwg D4271
REAM HOLE AS PER DWG
CUT RIVET AT 1.130"
C' SINK AT .220" X100 DEG FOR HOLE OPPOSITE TO HEAD

1X

16/09/14
DAS
38
9-89

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Quality Control

Memo

0.02

1

SEP 14 2016
DAS
38
9-89

120

Identify as per dwg & Stock Location:

0.00

120

Packaging

Packaging

Memo

0.01

S1376

1
DAS
6
9-89

SEP 15 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

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146864

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Item ID: D4271-027 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: End Fitting Assembly Aft Beam
Start Date: 6/8/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/10/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.10							
Quality Control									

MJS 1609-15
MJS 1609-15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Description Work Order Deviation		Disposition		Completed By	
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

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Work Order ID: 146864

146864

Parent Item: D4271-027

D4271-027

Parent Item Name: End Fitting Assembly Aft Beam

Start Date: 6/8/2016

Required Date: 6/10/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP revA 11.07.20 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4148-3 *D4148-3* Stud Receiver, Lower		Manufactured	No			100	Each	14.0000	1	1			DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST086				14					
				142482				14					
D4148-5 *D4148-5* Eyebolt Stud		Manufactured	No			100	Each	18.0000	1	1			DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST086				18					
				143355				18					
D4281-3 *D4281-3* Spacer		Manufactured	No			100	Each	1.0000	1	1			DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST090				1					
				123097				1					
D4419-3 *D4419-3* Aft Support Plate		Manufactured	No			100	Each	1.0000	2	2			DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST097				1					
				122964				1					

SEP 07 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order ID: 146864

146864

Parent Item: D4271-027

D4271-027

Parent Item Name: End Fitting Assembly Aft Beam

Start Date: 6/8/2016

Required Date: 6/10/2016

Start Qty: 1.00

Required Qty: 1.00

AN4C13A Purchased No

100 Each 138.0000 2 2

AN4C13A
BOLT

DAS
6
9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
OVER002	50	
m134508	50	
over003	50	
m134497	50	
ST344	38	
m134573	8	
m134754	30	

MS20427M4-20 Purchased No

100 Each 90.0000 1 1

MS20427M4-20
RIVET

16/09/14
DAS
36
9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	90	
118429	90	

MS20615-4M18 Purchased No

100 Each 227.0000 10 10

MS20615-4M18
Rivet

134955
DAS
6
9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	104	
m134370	50	
m134676	4	
m134762	50	
OVER007	100	
m134502	50	
m134606	50	
ST306	23	
m134134	23	

SEP 07 2016

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Shop Packet Print

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DQA: _____ Date: _____



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OTHER : ☐					

Picklist Print

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Work Order ID: 146864

146864

Parent Item: D4271-027

D4271-027

Parent Item Name: End Fitting Assembly Aft Beam

Start Date: 6/8/2016

Required Date: 6/10/2016

Start Qty: 1.00

Required Qty: 1.00

MS21043-4

Purchased

No

100

Each

1,070.000

2

2

MS21043-4

135390

Nut

Location

Loc Qty

Loc Code

DAS

FG

40

6

104603

40

9-89

GA

41

m132803

41

OVER007

300

m134502

300

ST302

689

m133769

12

m134249

77

m134634

300

m134754

300

NAS1149C0432R

Purchased

No

100

Each

1,641.000

4

4

NAS1149C0432R

135517

WASHER

Location

Loc Qty

Loc Code

DAS

GA

1320

6

m125807

427

9-89

m134676

893

ST266

321

m134073

321

SEP 07 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																